

Work Order ID 68353

Tuesday, April 12, 2011 10:09:42 AM



Page 1

Item ID: D3535-25

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 4/12/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 12.00

Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 11-04-12

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3535	Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3535 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Deburr if necessary

B11-4-19

(13)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-4-19

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

Sub 4/15

(711)

(72)

Pro →

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3535-25 PAR #: W/A Fault Category: Small Fab NCR: Yes ~~No~~ DQA: 11 Date: 11.05.05
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: 11 Date: 11/05/06

NCR: <u>68353</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>11/04/19</u>	<u>#</u> <u>100</u>	<u>Found Qty 2 parts that</u> <u>were cut too close to edge</u> <u>of sheet.</u> <u>R.L. Process (employee max cuts sheets</u> <u>to get every part)</u>	<u>11/04/19</u> <u>QSEN</u>	<u>→ Scrap + destroy Qty 2</u> <u>no replace.</u>	<u>11/04/19</u>	<u>11/04/19</u>	<u>QSEN</u>	<u>11/04/19</u>
								<u>11/04/19</u>

NOTE: Date & initial all entries

Work Order ID 68353

Tuesday, April 12, 2011 10:09:42 AM



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Item ID: D3535-25	Accept		Setup Start	
Revision ID:			Stop	
Item Name: Wearshoe				
Start Date: 4/12/2011	Start Qty: 12.00		Cust Item ID:	
Required Date: 4/15/2011	Req'd Qty: 12.00		Customer:	

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run Start	
	QC:	Date:	SPC (Y/N):	Date:	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Brake NC	NC BRAKE	0.00				<u>11X</u>			
Brake NC	Memo I-Form on CNC Brake as per Dwg D3535 using Jigs DT8261 and DT8326 Form joggle on Punch as per Dwg D3535 using Jig DT8158 Identify as D3535-25	0.00							
140 QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00				<u>416</u>			
150 Powdercoat	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
Powder Coating	Memo START TIME: 10:00 FINISH TIME: 10:30	0.00							

SB 11/04/19

=> m-k 11/04/20

Subaru

11 BR 11-4-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68353



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Item ID: D3535-25 Accept  Setup Start 
Revision ID:
Item Name: Wearshoe Stop 
Start Date: 4/12/2011 Start Qty: 12.00  Cust Item ID:
Required Date: 4/15/2011 Req'd Qty: 12.00  Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				11	0	11	11/04/21
170  Packaging Packaging	Identify as per dwg & Stock Location: <i>FP-18</i> Memo	0.00 0.00				11		11	11-4-21
180  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							11/4/21 <i>mf</i> 11-04-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, April 12, 2011 10:09:49 AM

Page 1

Work Order ID: 68353



Parent Item: D3535-25



Parent Item Name: Wearshoe

Start Date: 4/12/2011

Required Date: 4/15/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-02-15 JLM
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S20GA

Purchased

No

100

sf

67.4000

0.51

6.442105

7.



B11-4-19

304/316 .040 Sheet

Location

Loc Qty

Loc Code

MAT020

67.4

116437

25.4

116623

42

116623

13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	68353
Description: Wearshoe		Part Number:	D3535-25
Inspection Dwg: D3535 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1.888	✓		V 1B02	
1.937	+/-0.010	1.934	✓		V	
1.450	+/-0.010	1.450	✓		V	
5.450	+/-0.010	5.450	✓		T 1B01	
10.900	+/-0.010	10.900	✓		T	
16.350	+/-0.010	16.350	✓		T	
21.800	+/-0.010	21.800	✓		T	
Ø0.188	+0.005/-0.001	.192	✓		V	
12.750	+/-0.010	12.750	✓		T	
6.75	+/-0.030	6.75	✓		T	
6.00	+/-0.030	6.00	✓		T	
0.300	+/-0.010	.305	✓		V	
0.300	+/-0.010	.305	✓		V	
0.038	+/-0.010	.034	✓		V	

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 11-4-19	Date: 11/4/19	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue	KJ/EC/DD	

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

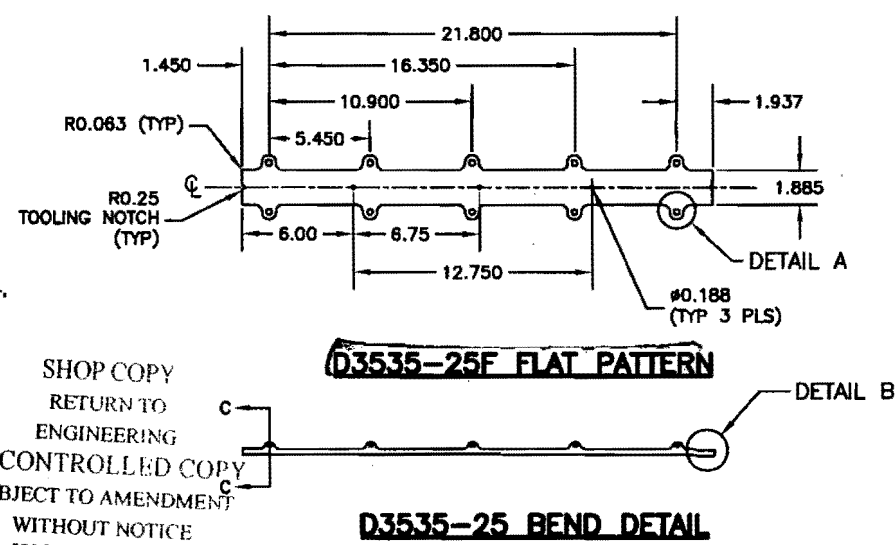
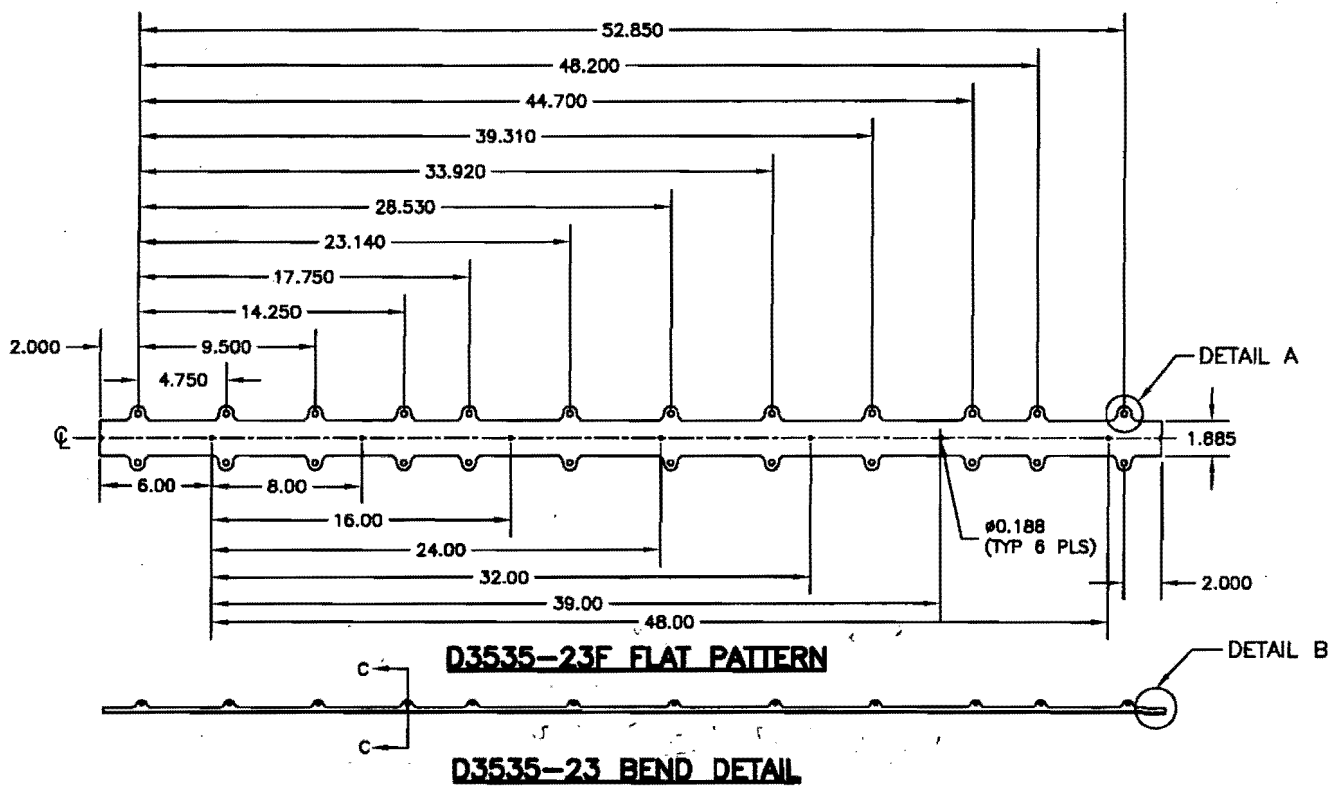
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DART

RELEASED
07 04 24

DESIGN CB	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	REV. B
CHECKED PH	APPROVED PH	DRAWING NO. D3535	SHEET 3 OF 7
DATE 07.04.17	TITLE WEARSHOE	SCALE 1:10	



- NOTES**
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
 - 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
 - 3) PART IS SYMMETRICAL ABOUT C
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) BREAK ALL SHARP EDGES TO 0.010 MAX
 - 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
 - 8) SEE PAGE 7 FOR DETAILS AND SECTION

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 68353 PH 11 04-11

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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